



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

MAY 03 2018

D205-633-021

Job Sheet 176707



003022

Part No: D205-633-021

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Simplex Tank Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/17/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:B Added D2565-111 05-09-09 KJ/JLM

MAY 03 2018

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/17/18	5/17/18	0.00	0.00	Start Up Stores/Pkg-1		MAY 03 2018
110	Packaging	1 pcs	5/17/18	5/17/18	0.00	0.00	Packaging1-2		
120	QC	1 pcs	5/17/18	5/17/18	0.00	0.00	QC4		
125	DC	1 pcs	5/17/18	5/17/18	0.00	0.00	DC		
130	Packaging	1 pcs	5/17/18	5/17/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	5/17/18	5/17/18	0.00	0.00	QC21		MAY 07 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D205-633-021 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP D205-633-021 Location: F3082

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	1 Ea (1 ea)	90-Start up Operation	5017090
AN4-14A	Bolt	1 Ea (1 ea)	90-Start up Operation	5042375
AN4-5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5044186
AN4-7A	Bolt	1 Ea (1 ea)	90-Start up Operation	5057520
AN44-7A	Eyebolt	1 Ea (1 ea)	90-Start up Operation	5007889
AN5-14A	Bolt	1 Ea (1 ea)	90-Start up Operation	5056344
D2022-101	Spacer	4 Ea (4 ea)	90-Start up Operation	50552892
D2022-103	Spacer	2 Ea (2 ea)	90-Start up Operation	5045077
D2562-011	Strut 25.79"	1 Ea (1 ea)	90-Start up Operation	5051246
D2563	Step Weldment Assembly	1 Ea (1 ea)	90-Start up Operation	5051493
D2565-101	Strut	1 Ea (1 ea)	90-Start up Operation	5050284
D2565-103	Strut	1 Ea (1 ea)	90-Start up Operation	5050488
D2565-105	Strut	1 Ea (1 ea)	90-Start up Operation	5053027
D2565-107	Strut	1 Ea (1 ea)	90-Start up Operation	5053058
D2565-109	Strut	1 Ea (1 ea)	90-Start up Operation	5052784
D2565-111	Strut	1 Ea (1 ea)	90-Start up Operation	5058504
D3437-041	Aft Strut Assembly	1 Ea (1 ea)	90-Start up Operation	5054118
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5041167
MS21042L5	Nut	2 Ea (2 ea)	90-Start up Operation	5055952
NAS1149D0463J	Washer	16 Ea (16 ea)	90-Start up Operation	5039036
NAS1149D0563J	Washer	3 Ea (3 ea)	90-Start up Operation	

5051493

5048156



Container No: S068278



Part: D205-633-021

Job No: 176707

Serial No/Batch: S068278

Revision:

Inspector:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL : 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 05/03/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	1	116	0
	AN4-14A	1	486	0
	AN4-5A	1	82	0
	AN4-6A	4	1,258	0
	AN4-7A	1	152	0
	AN44-7A	1	3	0
	AN5-14A	1	91	0
	D2022-101	4	61	0
	D2022-103	2	15	0
	D2562-011	1	4	0
	D2563	1	1	0
	D2565-101	1	2	0
	D2565-103	1	2	0
	D2565-105	1	2	0
	D2565-107	1	10	0
	D2565-109	1	2	0
	D2565-111	1	3	0
	D3437-041	1	2	0
	MS21042L4	8	3,046	0
	MS21042L5	2	930	0
	NAS1149D0463J	16	5,890	0
	NAS1149D0563J	3	1,531	0
Part Specifications				
Specifications could not be found.				

Plex 4/27/18 2:14 PM dart.lacelle.linda

Change Record

PAGE 1 OF 1

Part Number: D205-633-021/-022

Description: HELI-ACCESS STEP, HIGH GEAR LH/RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

**5.2 D205-633-021/-022/-023/-024/-025/-026 Heli-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED